FIG. 18

Reduction of Machine Direction Tensile Strength

■ CWP Rubber-Steel -■-- TAD Rubber-Steel △ CWP Perforate — TAD Perforate 120 100 Emboss Depth (.001 inch) 8 8 4 ន្តាំ %0.0 35.0% 30.0% 25.0% 20.0% 15.0% 10.0% 5.0% -2.0% -10.0% MD Dry Tensile Loss (%)

7 deg. sidewall - 9 deg. sidewall - 11 deg sidewall 34 N/P = Half Step/Full Step FIG. 19 ı₹ NZ Z 32 N = No Picking P = Picking 30 ∤Where; 28 Emboss Engagement (mils) Fiber Picking With 45 mil Embossing Rolls--Beveled Ovals 26 22 20 Base Sheet Caliper = 6.4mils $\frac{7}{\infty}$ NN 16 N/N

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Element Clearance (mils)

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FIG. 20

→ 7 deg. sidewall→ 9 deg. sidewall→ 11 deg sidewall

Fiber Picking With 42.5 mil Embossing Rolls--Beveled Ovals

